

Work Order ID 116262

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Item ID: D4445-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cable Guard

Start Date: 4/09/14

Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/18/14

Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals:

Process Plan: MLS

Date: 14-04-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4445

A

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D4445

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

DAS
23
9-89

14-08-26

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Item ID:	D4445-1	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Cable Guard					
Start Date:	4/09/14	Start Qty: 4.00	*4*	Cust Item ID:		
Required Date:	4/18/14	Req'd Qty: 4.00	*4*	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							DAS 08 9-88
120	HAAS CNC VERTICAL MACHINING #1					4	0		
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Mill as per folio FB072 & dwg D4445, FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-Deburr as required								
130		0.00							DAS 08 9-89
130	QC2- Inspect parts off machine FAI/FAIB					4	0		
QC	Memo	0.00							
Quality Control									
140		0.00							
140	QC8- Inspect parts - second check					4	0		
QC	Memo	0.00							
Quality Control	ENSURE D4445-1 IS MACHINE TO LENGTH AS PER DWG.								

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Item ID: D4445-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cable Guard

Start Date: 4/09/14 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 4/18/14 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation	Description
1	Start
2	Initialize variables
3	Calculate the sum of the first 10 natural numbers
4	Print the sum
5	End

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

Accept
Otv

Reject
QtyReject
Number

**Insp.
Stamp**

150

Identify as per dwg & Stock Location: S7260A 0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

4x

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~~OCT 01 2014~~

MCS

14-10-02

MLJ 14-10-01

Picklist Print

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Work Order ID: 116262

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Parent Item: D4445-1

D4445-1

Parent Item Name: Cable Guard

Start Date: 4/09/14

Required Date: 4/18/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11/10/05 NEW ISSUE JFS VERFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

sf

817.7082

(4)

MIJHMWB10

DAS

23

9-89

1408-26

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT018

817.7082

121278

9.6282

122575

47.6

123229

53

123949

6.96

124758

17.52

m128011

57

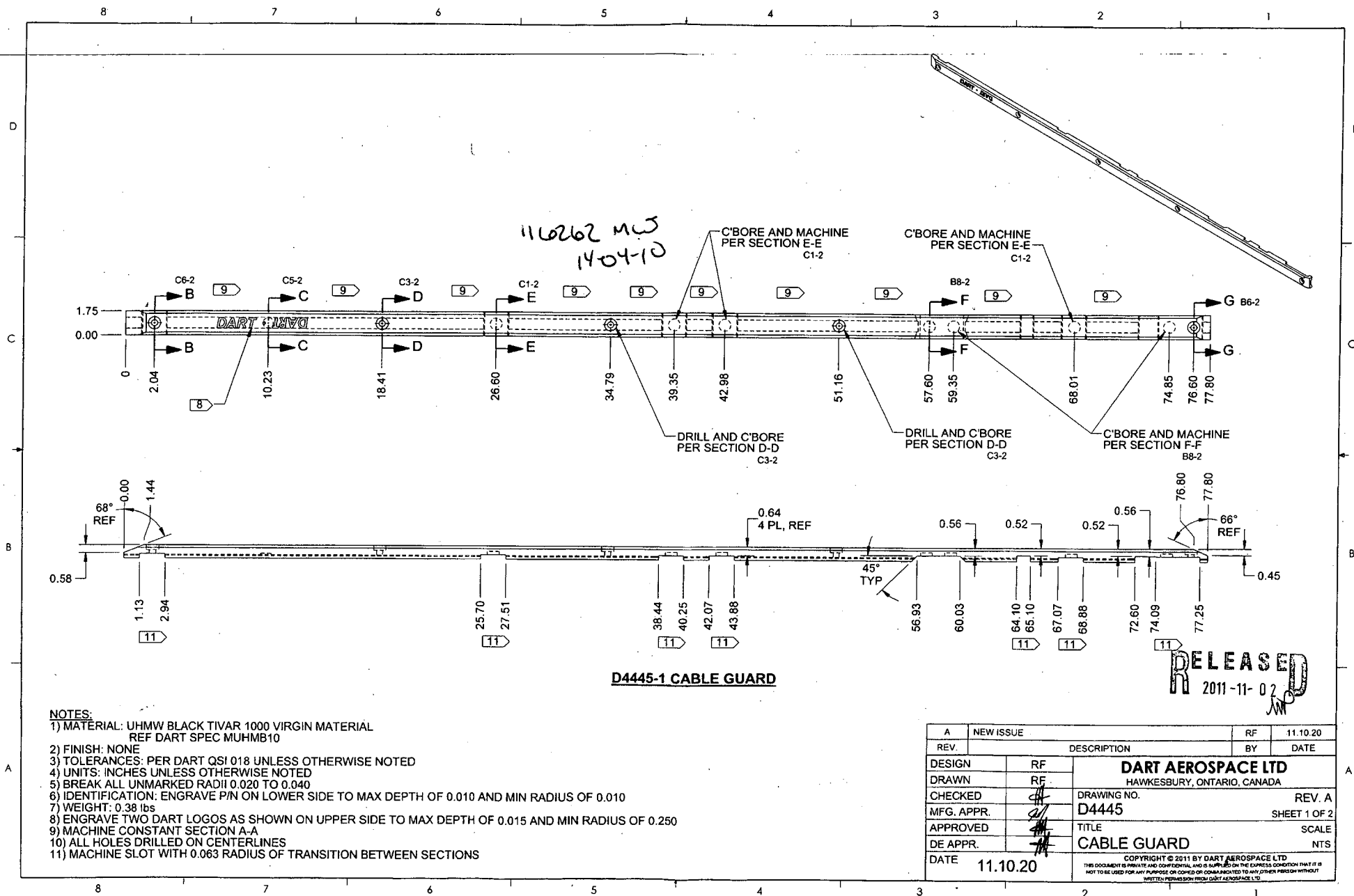
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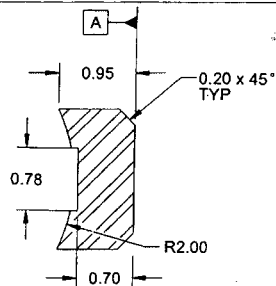
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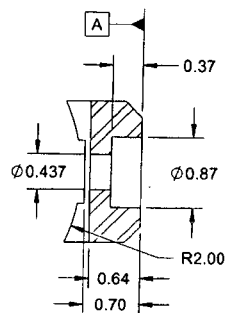
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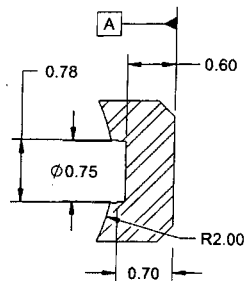
8 7 6 5 4 3 2 1



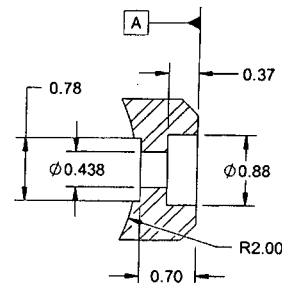
SECTION A-A C1-1
SCALE 3.5X TO C8-1



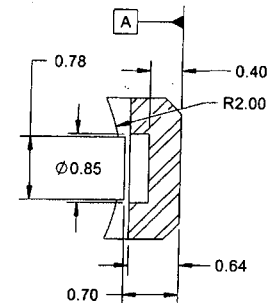
SECTION B-B C8-1
SCALE 3.5X



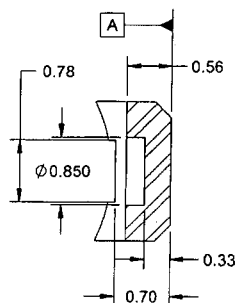
SECTION C-C C7-1
SCALE 3.5X



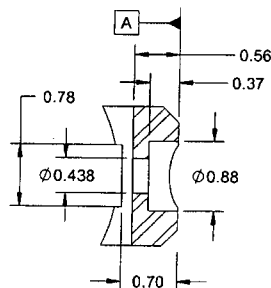
SECTION D-D C3-1
SCALE 3.5X C4-1
3 PL C8-1



SECTION E-E C2-1
SCALE 3.5X C4-1
4 PL C5-1
C6-1



SECTION F-F C1-1
SCALE 3.5X C3-1
3 PL



SECTION G-G C1-1
SCALE 3.5X

RELEASED
2011-11-02

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	CH	DRAWING NO. D4445	REV. A
MFG. APPR.	CH		SHEET 2 OF 2
APPROVED	CH	TITLE CABLE GUARD	SCALE NTS
DE APPR.	CH	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
DATE	11.10.20	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order:	116262
Description: Cable Guard		Part Number:	D4445-1
Inspection Dwg: D4445 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.04	+/-0.030	2.033	✓		Vern	GA-13
10.23	+/-0.030	10.218	✓		"	"
18.41	+/-0.030	18.405	✓		Tape	GA-12
26.60	+/-0.030	26.610	✓		"	"
34.79	+/-0.030	34.783	✓		"	"
39.35	+/-0.030	39.345	✓		"	"
42.98	+/-0.030	42.970	✓		"	"
51.16	+/-0.030	51.155	✓		"	"
57.60	+/-0.030	57.590	✓		"	"
59.35	+/-0.030	59.340	✓		"	"
68.01	+/-0.030	68.000	✓		"	"
74.85	+/-0.030	74.840	✓		"	"
76.60	+/-0.030	76.590	✓		"	"
77.80	+/-0.030	77.800	✓		"	"
0.58	+/-0.030	0.580	✓		Vern	GA-13
1.44	+/-0.030	1.440	✓		"	"
2.94	+/-0.030	2.937	✓		"	"
27.51	+/-0.030	27.50	✓		Tape	GA-12
40.25	+/-0.030	40.25	✓		"	"
43.88	+/-0.030	43.875	✓		"	"
60.03	+/-0.030	60.015	✓		"	"
0.56	+/-0.030	0.560	✓		Vern	GA-01
65.10	+/-0.030	65.090	✓		Tape	GA-12
68.88	+/-0.030	68.875	✓		"	"
0.52	+/-0.030	0.522	✓		Vern	GA-01
77.25	+/-0.030	77.250	✓		Tape	GA-12
77.80	+/-0.030	77.780	✓		"	"
0.45	+/-0.030	0.450	✓		Vern	GA-13
0.95	+/-0.030	0.948	✓		"	"
0.78	+/-0.030	0.776	✓		"	"
0.70	+/-0.030	0.697	✓		"	"
R2.00	+/-0.030	R2.00	✓		R-G	ref.
0.20 x 45°	+/-0.030 x +/-0.5°	0.190 x 45°	✓		Vern	GA-13
Ø0.437	+0.006/-0.001	Ø0.436	✓		"	"
Ø0.87	+0.010/-0.001	Ø0.870	✓		"	"
Ø0.75	+0.008/-0.001	Ø0.748	✓		"	"

DART AEROSPACE LTD		Work Order:	116262
Description: Cable Guard		Part Number:	D4445-1
Inspection Dwg: D4445 Rev: A		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.60	+/-0.030	0.596	✓		Vern	6A-13
Ø0.88	+0.010/-0.001	Ø0.870	✓		"	"
0.37	+/-0.030	0.372	✓		"	"
0.64	+/-0.030	0.634	✓		"	"
Ø0.850	+0.010/-0.001	Ø0.850	✓		"	"

Measured by: D.F.	DAS 08 9-89	Audited by: [Signature]	Preliminary Approval:
Date: 14/09/21		Date: 14/09/27	Date:

Rev	Date	Change	Revised by:	Approved
A	14.09.22	New Issue	KJ	[Signature]